

# Work Order ID 71783

Tuesday, July 12, 2011 8:57:35 AM



Page 1

Item ID: D3442-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Shim					
Start Date: 7/12/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 7/18/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 7-10-11	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3442	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3442								
341.052	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	<b>Memo</b>	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
	QC								
	<b>Memo</b>	0.00							
Quality Control									

B11-7-13

B11-7-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								

*n / AS*

*WA*

*SPD 11-07-20*

*(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/21  
MF  
11-07-21

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 8:57:47 AM

Page 1

Work Order ID: 71783

Parent Item: D3442-1

Parent Item Name: Shim





Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 05.09.02 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	139.3600	0.04	0.505263	1.		
304/316 .032 Sheet													

B11-7-13

Location

Loc Qty

Loc Code

020	5.8	
109057	5.8	
MAT020	133.56	
117379	37.56	
118271	96	

\_\_\_\_\_  
\_\_\_\_\_  
117379  
\_\_\_\_\_

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

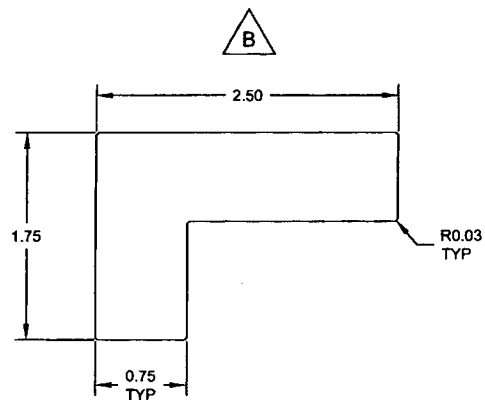
C

B

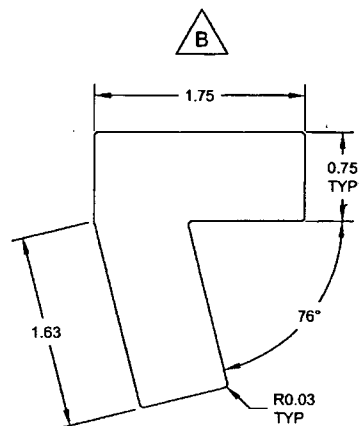
B

A

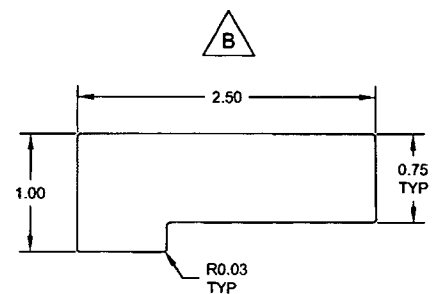
A



**D3442-1 SHIM**



**D3442-3 SHIM**



**D3442-5 SHIM**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71783

**RELEASED**  
2011-05-30  
*WJ*

- NOTES:**
- 1) MATERIAL D3442-1/-3: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 22 GAUGE (0.031 THICK) REF. DART SPEC. M304S22GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.03 lbs APPROX



B	REFORMAT. MATERIAL FOR -1 & -3 WAS 21 GAUGE. TOLERANCE UPDATED FOR ALL PARTS. (SEE PAR 10-005)	AJS	11.05.26
A	NEW ISSUE	PH	05.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.05.26		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3442

TITLE SHIM

REV. B  
SHEET 1 OF 1

SCALE NTS

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8 7 6 5 4 3 2 1

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